

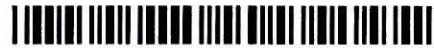


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4895-047

Job Sheet 173512



Part No: D4895-047

Job Qty: 3 ea

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV B IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	3/2/18	3/2/18	0.00	0.00	Start Up Waterjet		on 18/03/01
100	Waterjet	3 pcs	3/2/18	3/2/18	0.00	2.36	Waterjet1		on 18/03/01
110	CNC Vertical Machining	3 pcs	3/3/18	3/3/18	0.62	8.82	HAAS1-5		BA 18-05-05
120	QC	3 pcs	3/3/18	3/3/18	0.00	0.00	QC2 Machining-3		BA 18-05-05
150	QC	3 pcs	3/3/18	3/3/18	0.00	0.00	QC8 Machining-3		BA 18-05-05
160	HandFinish	3 pcs	3/3/18	3/3/18	0.00	0.57	HandFinish1		BA 18-05-05
170	QC	3 pcs	3/3/18	3/3/18	0.00	0.00	QC7-4		BA 18-05-05
171	Powdercoat	3 pcs	3/3/18	3/3/18	0.00	0.32	Powdercoat1		BA 18-05-05
172	QC	3 pcs	3/3/18	3/3/18	0.00	0.00	QC3		BA 18-05-05
180	Small Fab	3 pcs	3/5/18	3/5/18	0.00	0.71	Small Fab-8		BA 18-05-05
190	QC	3 pcs	3/5/18	3/5/18	0.00	0.00	QC5		BA 18-05-05
200	Packaging	3 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3-2		BA 18-05-05
210	QC21-SA	3 Ea	3/5/18	3/5/18	0.00	0.00	QC21		BA 18-05-05

M/38760

START: 9:35

OV.T: 3:00

FINISH: 0:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	9.0300 ft (3.01 ea)	90-Start up Operation	FM 1385410 80
D4859-1	Bushing	12 Ea (4 ea)	180-Small Fab	5097596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	9	16	0
180-Small Fab	D4859-1	12	16	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 1:46 PM dart.logan.david

Add 12.6



Container No: S047892



Part: D4895-047

Job No: 173512

Serial No/Batch: S047892

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/05/18

DART AEROSPACE LTD		Work Order: 13512
Description: Aft Outboard Beam		Part Number: D4895-7
Inspection Dwg: D4895	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓		Tape	ref.
	R1.50	+/-0.030	R1.500	✓		R-G	ref.
	R0.38	+/-0.030	R0.375	✓		"	"
	4.63	+/-0.030	4.625	✓		H-G	31006
	5.75	+/-0.030	5.748	✓		Vern	GA-13
	0.250	+/-0.010	0.249	✓		Mic	GA-03
	0.150	+/-0.010	0.149	✓		Vern	GA-13
	3.00	+/-0.030	2.998	✓		"	"
	R0.43	+/-0.030	R0.430	✓		R-G	ref.
	0.200	+/-0.010	0.201	✓		Mic	GA-03
	0.750	+/-0.010	0.748	✓		Vern	GA-13
	Ø0.425	+0.000/-0.002	0.4245	✓		Mic/T-G	GA-03/ref.
	6.97	+/-0.030	6.973	✓		H-G	31006
	0.93	+/-0.030	0.928	✓		Vern	GA-13
	0.85	+/-0.030	0.848	✓		"	"
	1.00	+/-0.030	1.014	✓		"	"
	R0.13	+/-0.030	R0.125	✓		R-G	ref.
	0.150	+/-0.010	0.152	✓		Mic	118-120
	Ø0.377	+0.006/-0.001	Ø0.378	✓		Vern	GA-13
	3.00	+/-0.030	2.997	✓		"	"
	1.15	+/-0.030	1.150	✓		"	"
	Ø1.00	+/-0.030	Ø0.998	✓		"	"
	2.300	+/-0.005	2.300	✓		"	"
	0.60	+/-0.030	0.600	✓		"	"
	0.80	+/-0.030	0.799	✓		"	"
	3.600	+/-0.005	3.600	✓		"	"
	1.800	+/-0.005	1.800	✓		"	"
	1.75	+/-0.030	1.7485	✓		"	"
	3.50	+/-0.030	3.497	✓		"	"
Manual Mill	0.25	+/-0.030	0.254	✓		D-G	GA-08
	5.50	+/-0.030	5.502	✓		Vern	GA-13
	12.000	+/-0.005	12.000	✓		Vern	CNC-02
	1.55	+/-0.030	1.551	✓		"	"
	Ø0.465 X 90°	+/-0.010 x 0.5°	Ø0.473x90°	✓		"	"
	R0.25	+/-0.030	R0.250	✓		R-G	ref.
	0.500	+/-0.010	0.498	✓		Mic	GA-03

Measured by: A.E.	Audited by: mm1	Preliminary Approval:
Date: 18-05-05	Date: 18/05/08	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	